

Work Order ID 122677

Tuesday, July 22, 2014 8:43:22 AM

122677

Page 1

Item ID: D4653-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Vent Manifold Assembly
 Start Date: 8/19/14 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 8/19/14 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 14-07-23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4653	REV A

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

170		0.00							
170									
Small Fab	Memo	0.00							
Small Fab	INSTALL FITTING ASSEMBLY WITH LUBE AS PER DWG								
	BATCH #: <u>1110340</u>								

180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									

6 FF 14-08-12

6 FF 14-08-12

6 5 11/14/13 DAS 38 9-89 14/08/13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Tuesday, July 22, 2014 8:43:22 AM

122677

Page 2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Vent Manifold Assembly

Stop *NS2*

Start Date: 8/19/14 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 8/19/14 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation	Description
1	Start of the program
2	Initial values of the variables
3	Calculation of the first term of the series
4	Calculation of the second term of the series
5	Calculation of the third term of the series
6	Calculation of the fourth term of the series
7	Calculation of the fifth term of the series
8	Calculation of the sixth term of the series
9	Calculation of the seventh term of the series
10	Calculation of the eighth term of the series
11	Calculation of the ninth term of the series
12	Calculation of the tenth term of the series
13	Calculation of the eleventh term of the series
14	Calculation of the twelfth term of the series
15	Calculation of the thirteenth term of the series
16	Calculation of the fourteenth term of the series
17	Calculation of the fifteenth term of the series
18	Calculation of the sixteenth term of the series
19	Calculation of the seventeenth term of the series
20	Calculation of the eighteenth term of the series
21	Calculation of the nineteenth term of the series
22	Calculation of the twentieth term of the series
23	Calculation of the twenty-first term of the series
24	Calculation of the twenty-second term of the series
25	Calculation of the twenty-third term of the series
26	Calculation of the twenty-fourth term of the series
27	Calculation of the twenty-fifth term of the series
28	Calculation of the twenty-sixth term of the series
29	Calculation of the twenty-seventh term of the series
30	Calculation of the twenty-eighth term of the series
31	Calculation of the twenty-ninth term of the series
32	Calculation of the thirtieth term of the series
33	Calculation of the thirty-first term of the series
34	Calculation of the thirty-second term of the series
35	Calculation of the thirty-third term of the series
36	Calculation of the thirty-fourth term of the series
37	Calculation of the thirty-fifth term of the series
38	Calculation of the thirty-sixth term of the series
39	Calculation of the thirty-seventh term of the series
40	Calculation of the thirty-eighth term of the series
41	Calculation of the thirty-ninth term of the series
42	Calculation of the fortieth term of the series
43	Calculation of the forty-first term of the series
44	Calculation of the forty-second term of the series
45	Calculation of the forty-third term of the series
46	Calculation of the forty-fourth term of the series
47	Calculation of the forty-fifth term of the series
48	Calculation of the forty-sixth term of the series
49	Calculation of the forty-seventh term of the series
50	Calculation of the forty-eighth term of the series
51	Calculation of the forty-ninth term of the series
52	Calculation of the fiftieth term of the series
53	Calculation of the fifty-first term of the series
54	Calculation of the fifty-second term of the series
55	Calculation of the fifty-third term of the series
56	Calculation of the fifty-fourth term of the series
57	Calculation of the fifty-fifth term of the series
58	Calculation of the fifty-sixth term of the series
59	Calculation of the fifty-seventh term of the series
60	Calculation of the fifty-eighth term of the series
61	Calculation of the fifty-ninth term of the series
62	Calculation of the sixtieth term of the series
63	Calculation of the sixty-first term of the series
64	Calculation of the sixty-second term of the series
65	Calculation of the sixty-third term of the series
66	Calculation of the sixty-fourth term of the series
67	Calculation of the sixty-fifth term of the series
68	Calculation of the sixty-sixth term of the series
69	Calculation of the sixty-seventh term of the series
70	Calculation of the sixty-eighth term of the series
71	Calculation of the sixty-ninth term of the series
72	Calculation of the seventieth term of the series
73	Calculation of the seventy-first term of the series
74	Calculation of the seventy-second term of the series
75	Calculation of the seventy-third term of the series
76	Calculation of the seventy-fourth term of the series
77	Calculation of the seventy-fifth term of the series
78	Calculation of the seventy-sixth term of the series
79	Calculation of the seventy-seventh term of the series
80	Calculation of the seventy-eighth term of the series
81	Calculation of the seventy-ninth term of the series
82	Calculation of the eightieth term of the series
83	Calculation of the eighty-first term of the series
84	Calculation of the eighty-second term of the series
85	Calculation of the eighty-third term of the series
86	Calculation of the eighty-fourth term of the series
87	Calculation of the eighty-fifth term of the series
88	Calculation of the eighty-sixth term of the series
89	Calculation of the eighty-seventh term of the series
90	Calculation of the eighty-eighth term of the series
91	Calculation of the eighty-ninth term of the series
92	Calculation of the ninetieth term of the series
93	Calculation of the ninety-first term of the series
94	Calculation of the ninety-second term of the series
95	Calculation of the ninety-third term of the series
96	Calculation of the ninety-fourth term of the series
97	Calculation of the ninety-fifth term of the series
98	Calculation of the ninety-sixth term of the series
99	Calculation of the ninety-seventh term of the series
100	Calculation of the ninety-eighth term of the series
101	Calculation of the ninety-ninth term of the series
102	Calculation of the hundredth term of the series
103	Calculation of the hundred-first term of the series
104	Calculation of the hundred-second term of the series
105	Calculation of the hundred-third term of the series
106	Calculation of the hundred-fourth term of the series
107	Calculation of the hundred-fifth term of the series
108	Calculation of the hundred-sixth term of the series
109	Calculation of the hundred-seventh term of the series
110	Calculation of the hundred-eighth term of the series
111	Calculation of the hundred-ninth term of the series
112	Calculation of the hundred-tenth term of the series
113	Calculation of the hundred-eleventh term of the series
114	Calculation of the hundred-twelfth term of the series
115	Calculation of the hundred-thirteenth term of the series
116	Calculation of the hundred-fourteenth term of the series
117	Calculation of the hundred-fifteenth term of the series
118	Calculation of the hundred-sixteenth term of the series
119	Calculation of the hundred-seventeenth term of the series
120	Calculation of the hundred-eighteenth term of the series
121	Calculation of the hundred-nineteenth term of the series
122	Calculation of the hundred-twentieth term of the series
123	Calculation of the hundred-twenty-first term of the series
124	Calculation of the hundred-twenty-second term of the series
125	Calculation of the hundred-twenty-third term of the series
126	Calculation of the hundred-twenty-fourth term of the series
127	Calculation of the hundred-twenty-fifth term of the series
128	Calculation of the hundred-twenty-sixth term of the series

Set Up/ Run Hours

Tool ID

Tool #	Plan Code
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**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

190

Identify as per dwg & Stock Location: 5T114

0.00

190

Packaging

Memo

0.00

Packaging

6x DAS AUG 13 2014
28
9-89

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MLJ 140814

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		
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Tuesday, July 22, 2014 8:43:22 AM

122677

D4653-041

Required Date: 8/19/14

Required Qty: 12.00

IPP REV B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty per Kit Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4653-3		Manufactured	No			110	Each	15.0000	1	12			
<div> <div>*D4653-3*</div> <div>Collar</div> </div> <div> <div>122662</div> <div></div> </div> <div> <div>**</div> <div>6</div> <div>FF 14-08-12</div> </div>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		12			
				ST114	120352	15							
				116061		6							
				119842		9							
D4653-045		Manufactured	No			170	Each	0.0000	2	24			
<div> <div>*D4653-045*</div> <div>Fitting Assembly</div> </div> <div> <div></div> <div></div> </div> <div> <div>**</div> <div>FF</div> <div>14-08-12</div> </div>													

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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